Work Order ID 112237 *112237* Page 1 January-30-14 11:20:15 AM Accept *N900040100* D3488-042 Setup Start Item ID: Revision ID: Stop Blade Fitting RH **Item Name: Start Oty: 10.00** Cust Item ID: **Start Date:** 1/30/14 Req'd Qty: 10.00 Required Date: 1/30/14 Customer: Reference: Run Start Date: 14-01-3 (Tooling: Process Plan: MLJ Date: Approvals: Stop QC: Date: SPC (Y/N): Date: *NR2* Reject Set Up/ Tool ID Tool # Plan Accept Reject Insp. Sequence ID/ Operation **Qty** Number Stamp Work Center ID Description Code Otv **Run Hours** Draw Nbr **Revision Nbr** D3488 Rev B REV D **DSK 101** 0.00 100 DOOSAN LATHE

100 Doosan Doosan Lathe

Memo

0.00

1-Turn as per Dwg DSK 101 & Folio FA625

2-Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

410

QC

Memo

Quality Control

DQA:	-		Date:	_										7	DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		Wa	ork Order up	date only	7	AEROSPACE
QA Closed.		-i	Date.							-					
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Part N	J۸					Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.	1	Quality
	••••					Use-as-is			noforming	Finishing			re/Packaging	7	Other
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		Bending				Bend	<u> </u>	1	Program		L	Outside Dim	<u> </u>	→	essure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	\vdash	Grain			L	Over/Under		-	et-up
		Cracks			L	Broken/Damage/Defect		Hardwa			lacksquare	Part Incorre	 	—	emperature/Cure
		Crimp/Kii	nk/Ripple	/Wave	<u> </u>	Burrs	_	4 '	ion Incomplete/U		<u>_</u>	Part Lost/Mi	_	_	'eld
	<u> </u>	Cuffs			_	Contamination	<u>_</u>	-i	tions Incomplete/		<u> </u>	Part Moved		\w	rong Stock Pulled
		Crushing				Countersink	<u></u>	- '	gned/off center		\vdash	Positioned V	_	_	
		Heat Trea				Cut Too Short	_	Mislab				Power Loss/	Surge	lo	ther
		Inspectio		Tube		Drawing	\vdash	Misrea							
		Marks/Cl	natter		_	Drill Holes		Off-set							
	$ldsymbol{le}}}}}}$	Turning S	equence		L	Finish	\perp	4	Calibration						
		Wave/Tw	ist in Tul	be		Fit/Function		Out of	Sequence						

Work Ord January-30-14				*112	237*							Page 2
Item ID: Revision ID:	D3488-042			Accept	*N.90	0040	100)* s	etup S	tart Stop		S1*
Item Name: Start Date: Required Date Reference:	Blade Fitting 1/30/14: 1/30/14	Start Qty: 10.00 Req'd Qty: 10.00	*10 *10		Cust Ite Custom				, o	nop	*N:	S2*
Approvals:		an:	Date:	Tooling: SPC (Y/N):		Date:		R		tart Stop		R1* R <i>2</i> *
Sequence ID/ Work Center 1	D	Operation Description		Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	Reject Qty		Reject Iumber	Insp. Stamp
*120 *120* HAAS 1 HAAS CNC vertice	ol machine #1	HAAS CNC VERTICAL Memo	MACHINING #1	0.00					_Ø		6	[isP [14]03 14
TIAAS CIVE VEHIC	ai maciinic #1	1-Machine a	s per rono mozræ b	g 55 1002 Beouti								
130 *120* QC Quality Control		QC2- Inspect parts off m. Memo	achine FAI/FAIB	0.00				10	<i>J</i>	<u>~</u> .		/14/03/1
140		QC8- Inspect parts - seco	ond check	0.00								C 1 F1.

0.00

Memo

140

Quality Control

DQA:			Date:												
						WORK ORDER NON	-CC	ONFO	RMANCE / UP						AEROSPACE
QA Closed:			Date:							· · · · · · · · · · · · · · · · · · ·	Wo	rk Order up	date only	$oldsymbol{ol}}}}}}}}}}}}}}}}}}$	
Work Orde	or:					DISPOSITION				AGAINST I	DEF	PARTMENT	PROCESS		
· · · · · · · · · · · · · · · · · · ·	•	· · · <u>-</u> ·			_	Rework	1		Skid-tube	Crosstube	\neg		Water Jet	\neg	Engineering
Part N	lo.	•				Scrap			Machining	Small Fab	╗	Pro	d. Eng. Coor.	╗	Quality
	•			,		Use-as-is		Therr	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR I	No.					Suspected Unapproved]		Large Fab	Composite			Supplier	لـ	
Root					Desc	ription of work order update		nitial	Actio	on		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion		Date	Verification	ı	QC Inspector
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	Ŭ	Bending				Bend		Folio/F	Program			Outside Dim	ensions		Pressure/Forced
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		Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorre	ci		Temperature/Cure
· '		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unc	qualified		Part Lost/Mi	issing		Weld
ļ		Cuffs				Contamination		Instruc	tions Incomplete/Ur	nclear		Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center			Positioned V	Vrong _		
		Heat Trea	at			Cut Too Short		Mislab	eled			Power Loss/	Surge [Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d	•					
		Marks/Ch	natter			Drill Holes		Off-set							
		Turning S	equence	,		Finish		Out of	Calibration			.			
		Wave/Tw	ist in Tub	oe .		Fit/Function	L	Out of	Sequence			-			

Work Orde					*112	237	' *							Page 3
Item ID: Revision ID:	D3488-042				Accept	*No	ററ	040	100)*	Setup	Start	*N	S1*
Item Name:	Blade Fittin	g RH			Fig.							Stop	*N	S2*
Start Date: Required Date: Reference:	1/30/14	Start Qty: 10.0 Req'd Qty: 10.0		*10* *10*	(e)		t Item I tomer:	D:						
Approvals:	Process I	Plan: G	Date:		Tooling:		D:	ate:			Run	Start	*N	R1*
•	QC:		Date:		SPC (Y/N):		D:	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description Chemical Conversion	a Coat per OSI00	5 / 1	Set Up/ Run Hours	To	ol ID	Tool #	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp
150 HandFinish Hand Finishing		Memo	Coat per Q3100.	J 4.1	0.00					10		UG)	4-3-	19
		ę												
160 *1 An* Powdercoat Powder Coating		White Gloss(Ref:4.3 //// Wemo STARET	5.1) per QSI005 OS 7 PIME:	11:05	0.00 0.00 Oyed-temperature	:				10	_ Ø	\ pf-	3.H	7 DAG 9. 4.6. 9.8.9.9.9.9.9.9.9.9.9.9.9.9.9.9.9.9.9.

170

QC3- Inspect Part Finish

0.00

*17**0***

Memo

0.00

Quality Control

×10RH & 11/03/20

DQA:			Date:										TRAGE
						WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE			_	AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde						DISPOSITION			AGAINST	DE	PARTMENT,	PROCESS	
Work Orug	=1.		_			Rework	ıl		Skid-tube Crosstube	Г		Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab	\vdash	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1		noforming Finishing	\vdash		re/Packaging	Other
NCR I	۱o. ₋					Suspected Unapproved			Large Fab Composite			Supplier	
Root					Desci	ription of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													,
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Handling/Pre	Щ												
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Offset/Setup	-						1						
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		Bending				Bend		 Folio/I	Program	Г	Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	v	\vdash	Over/Under	tolerance	Set-up
	Г	Cracks				Broken/Damage/Defect		Hardw	are		Part Incorre	ci	Temperature/Cure
	Г	Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Г	Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	<u> </u>
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	'Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Cl	natter			Drill Holes		Off-set					
Ì		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tuk	be		Fit/Function		Out of	Sequence				

112237

Page 4 January-30-14 11:20:15 AM Accept D3488-042 Item ID: *N900040100* Setup Start **Revision ID:** Stop Blade Fitting RH **Item Name:** *10* **Start Date:** 1/30/14 **Start Oty: 10.00** Cust Item ID: Required Date: 1/30/14 Rea'd Otv: 10.00 *10* Customer: Reference: Start Run Approvals: Process Plan: Date: **Tooling:** Date: Stop Date: _____ SPC (Y/N): OC: Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Qty Otv Stamp Description Run Hours Code Number 180 0.00 HandFinishing *120* HandFinish 0.00 Hand Finishing Anstall Inserts as per Dwg D3488 190 QC5- Inspect part completeness to step on W/O 0.00 10 6 H3-26. *100* OC 0.00 Memo Quality Control Identify as per dwg & Stock Location: 10-00 YIORH & Il MO3/ZS 200 0.00 Packaging Memo Packaging

DQA:			Date:			WORK ORDER NON-	cc	NIEOI	DMARICE / II	IDDATE				DART
QA Closed:			Date:			WORK ORDER NON-		NITOI	NIVIAINCE / O		Woı	rk Order up	date only	AEROSPACE
Work Orde	ar.					DISPOSITION				AGAINST I	DEP	ARTMENT/	PROCESS	
WORK Orde	-					Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	10.					Scrap			Machining	Small Fab	_		d. Eng. Coor.	Quality
NCR N	lo. ِ				<u> </u>	Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier	Other
Root					Desc	ription of work order update	ı	nitial	Ac	tion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	\dashv	Date	Verification	QC Inspector
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		Bending				Bend		Folio/F	Program	ſ		Outside Dim	ensions $ ag{}$	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	H	Grain				Over/Under		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		-	Part Incorred	<u></u>	Temperature/Cure
<u>'</u>		Crimp/Kir	nk/Ripple	/Wave		Burrs	厂	Inspect	ion Incomplete/L	Jnqualified		Part Lost/Mi	ssing	Weld
		Cuffs		•		Contamination		4 '	tions Incomplete,	· ·		Part Moved	, F	Wrong Stock Pulled
		Crushing				Countersink		4	gned/off center			Positioned V	ــــ Vrong	
]	\vdash	Heat Trea	at			Cut Too Short		Mislab	=			Power Loss/	Surge	Other
		Inspectio		Tube		Drawing		Misrea	d	•			<u> </u>	
		Marks/Ch				Drill Holes		Off-set			-			
	Г	Turning S	equence			Finish		Out of	Calibration		-			
		Wave/Tw				Fit/Function		Out of	Sequence					

Work Order ID 112237 *112237* Page 5 January-30-14 11:20:15 AM Accept *N900040100* Item ID: D3488-042 Setup Start **Revision ID:** Item Name: Blade Fitting RH *10* **Start Date:** 1/30/14 **Start Otv:** 10.00 **Cust Item ID:** Required Date: 1/30/14 Rea'd Otv: 10.00 *10* Customer: Reference: Start Run Approvals: Process Plan: Date: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Insp. Accept **Work Center ID** Qty Oty Number Stamp Description Run Hours Code OC21- Final Inspection - Work Order Release 0.00 210 MLJ 14-03-28 MF 14-3-28 *210*

0.00

Memo

Quality Control

DQA:			Date:										
						WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	or.					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
WOIK OIG				-	_	Rework	ıl		Skid-tube Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab	_	Pro	d. Eng. Coor.	Quality
	•				_	Use-as-is			noforming Finishing		Rec/Stor	e/Packaging	Other
NCR N	۱o. ₋					Suspected Unapproved			Large Fab Composite			Supplier	
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													•
Equip/Tooling	Щ												
Handling/Pre													
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		Bending				Bend	Г] Folio/I	Program	Г	Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	Г	Grain	· ·		Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect	Г	Hardwa	are		Part Incorre	ci 📙	Temperature/Cure
	Г	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	issing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		4	gned/off center		Positioned V		-
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	ре		Fit/Function		Out of	Sequence				

January-30-14 11:20:14 AM

Work Order ID:

112237

Parent Item:

D3488-042

Parent Item Name:

Blade Fitting RH

Comments:

IPP Rev:A New Issue 06-02-28 JLM

IPP Rev:B As per Rev B 06-03-30 JLM
IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 10.00

Required Qty: 10.00

	IPP Rev:C Now C	n Doosan Latne J	LIVI V	mned BY:DD									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit		Qty Issued	Date Issued	Status
ALS7-1032-225 ¥ Insert ALS4 10	32-225	Purchased	No				Each	80.0000	MI	AII	G (140)	H	14/03/2
<i>/ .</i> (/-3				Location		Loc Qty	Lo	c Code					
				FG		80							
				118	520	80							
D6103-003 Round Billet, Aluminum		Manufactured	No				Each	20.0000		10	27	14-	2-3
				Location		Loc Oty	<u>La</u>	oc Code					
				MAT043		20							
				110	129	20				O			

DQA:			Date:						•				TRAC
			0-4			WORK ORDER NON	-CC	ONFO	RMANCE / UPD		/ork Order up	data anly	AEROSPACE
QA Closed:			Date:				-			V	rork Order up	date only	1
Work Orde	r:					DISPOSITION				AGAINST D	EPARTMENT,	PROCESS	
TTO IN OTO	-				_	Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is		Therr	moforming	Finishing	Rec/Sto	e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite]	Supplier	
	-				Daga	intian of work and an undate		nitial	Action	<u> </u>	Sign &		
Root	- 1	Data	· Cham	Otre	Desci	ription of work order update or non-conformance	1	illuai iief Eng			Date	Verification	QC Inspector
Cause	┥	Date	Step	Qty		or non-comormance	CII	ilei ciig	Descript	tion	Date	Vernication	Qe nispector
Design Doc/Data	\dashv						Ì						
Equip/Tooling	\dashv												
Handling/Pre	┪						1						
Material	\dashv		į.		}	,					1		
Operator	┫												
Offset/Setup													
Process				İ									
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Landi	ng G	iear .			_	General		,		F	_	_	- 1
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			ot Concer	ntric		BOM/Route	\vdash	Grain		-	Over/Under		Set-up
1	Щ	Cracks			<u> </u>	Broken/Damage/Defect	\vdash	Hardw		·	Part Incorre	<u> </u>	Temperature/Cure
			nk/Ripple	e/Wave	-	Burrs	\vdash	4 `	tion Incomplete/Unq	-	Part Lost/M		Weld
		Cuffs			_	Contamination	\vdash	-	tions incomplete/Un	clear	Part Moved	-	Wrong Stock Pulled
		Crushing			 	Countersink	-	-	gned/off center	·	Positioned V	· -	704
		Heat Tre			-	Cut Too Short	-	Mislab		Ŀ	Power Loss/	Surge	Other
	-		on Strip in	Tube		Drawing	-	Misrea					
	\vdash	Marks/C			\vdash	Drill Holes	\vdash	Off-set					
	_	•	Sequence		-	Finish Fit /Function	\vdash	4	Calibration				
	l	wave/Iv	vist in Tul	be		Fit/Function		LOut of	Sequence				

DART AEROSPACE LTD	Work Order:	112237
Description: Blade Fitting; RH / Turning Detail for D3488-1/-2	Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
Lathe Section								
Ø2.150	+/-0.005	2,147						
Ø2.780	+/-0.005	3. 1.50						
Ø3.125	+/-0.010	3,125						
Ø3.346	+/-0.010	03346	1					
0.125 x 45°	+/-0.010 x +/-0.1°	125 x45°						
8.000	+0.030/-0.000	8.015						
9.250	+/-0.010	3,250						
0.188	+/-0.010	187						
R0.032	+/-0.010	B.031						
R0.062	+/-0.010	R060	//					
Ø0.297	+0.005/-0.001	.300						
Ø0.430	+/-0.010	-431						
0.100	+/-0.010	.102						
0.125	+/-0.010	.130)	1/					
2.620	+/-0.010	7.620						
3.500	+/-0.010	3.500						
1.005	+/-0.010	1.005						
Ø0.484	+0.005/-0.001	,484						
1.180	+/-0.010	1.180	/,					
3.150	+/-0.010	3,100	1					
3.070	+/-0.010	3070				_		
R0.063	+/-0.010	R.060						
14-21-21-21-21-21-21-21-21-21-21-21-21-21-								

DART AEROSPACE LTD	Work Order:	1/2237
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2	Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2

Comments	Method of Inspection	Reject	Accept	Actual Dimension	Tolerance	Drawing Dimension
		<u> </u>	ng Section	Milli		
haure win	<u>#</u> —		/	0 508	+0.006/-0.001	Ø0.508
Hight cause	31006		/	0 744	+/-0.010	0.750
Vem	MJP-04			1 498	+/-0.010	1.500
Very	(nc-02		/	11.186	+/-0.030	11.18
Padicio , anne			/	0 062	+/-0.010	R0.062
Ven	MJP-04			0.125	+/-0.010	0.125
Height rouse	31006		/	0 590	+/-0.010	0.590
Vim	MJP-04		/	0.796	+/-0.010	0.793
High Cour	31006.		/	1.355	+/-0.010	1.351
VIIM -	MJP-04		/	1. 3/2	+/-0.010	1.317
Heigh gange	31006			1,803	+/-0.010	1.802
				<u> </u>		

Measured by:	MUP	Audited by: JFL	Prototype Approval:	N/A
Date:	14/03/14	Date: 2014-03-18	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.03.31	New Issue	KJ/JLM	
В	08.09.19	Reformat P/O D3488-042	KJ/JLM 1,A	21
С	08.12.02	Dimension 8.000 removed	KJ/JLM 🛠	



